

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84401

84401

Page 2

May-11-12 8:23:54 AM

Item ID: D4526-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Maintenance Step Assembly
 Start Date: 11/05/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 25/05/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST270</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

4/6/14

12/6/14

MF 12-06-14

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Picklist Print

May-11-12 8:23:57 AM

Page 1

Work Order ID: 84401

84401

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 *D4092-1* Maintenance Step		Manufactured	No			100	Each	6.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
				77852				1					
				80564				2					
				81734				2					
				ST241A				1					
				74303				1					
D4526-043 *D4526-043* Tube Assembly		Manufactured	No			100	Each	9.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				3					
				82317				3					
				ST254				6					
				80087				6					
D4527-1 *D4527-1* Bracket		Manufactured	No			100	Each	8.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST195				8					
				80088				7					
				80562				1					

B84402
4X

EP 5/12/06/12

EP 5/12/06/12

EP 5/12/06/12

1

1

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Page 2

Work Order ID: 84401

Parent Item: D4526-042

Parent Item Name: Maintenance Step Assembly

84401

D4526-042

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 2.00

Required Qty: 2.00

D4527-3

Manufactured No

100

Each

8.0000

1

2

D4527-3

Bracket

**

EP 12/06/12

Location

Loc Qty

Loc Code

ST195

8

77208

1

80086

6

82316

1

MS21042L3

Purchased

No

100

Each

2,857.000

10

20

MS21042L3

Nut

**

EP 12/06/12

Location

Loc Qty

Loc Code

ST300

2857

117885

32

119017

1117

119075

138

121349

590

121444

980

MS24694-S55

Purchased

No

100

Each

90.0000

8

16

MS24694-S55

Screw

**

EP 12/06/12

Location

Loc Qty

Loc Code

ST289A

90

119307

33

120910

55

121444

2

May-11-12 8:23:57 AM

Shop Packet Print

Page 2

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Page 3

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Parent Item: D4526-042

Parent Item Name: Maintenance Step Assembly

84401

D4526-042

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 2.00

Required Qty: 2.00

MS24694-S75

Purchased

No

100

Each

40.0000

2

4

MS24694-S75

Screw

**

EP 5/12/06/12

Location

Loc Qty

Loc Code

GA

15

119892

5

121349

10

ST289A

25

121415

25

4

NAS1149D0332J

Purchased

No

100

Each

3,217.000

10

20

NAS1149D0332.J

Washer

**

EP 5/12/06/12

Location

Loc Qty

Loc Code

ST297

1000

121708

1000

ST298

2217

105793

12

110985

4

117087

89

119042

32

119717

500

120644

72

121011

1508

20

May-11-12 8:23:58 AM

Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

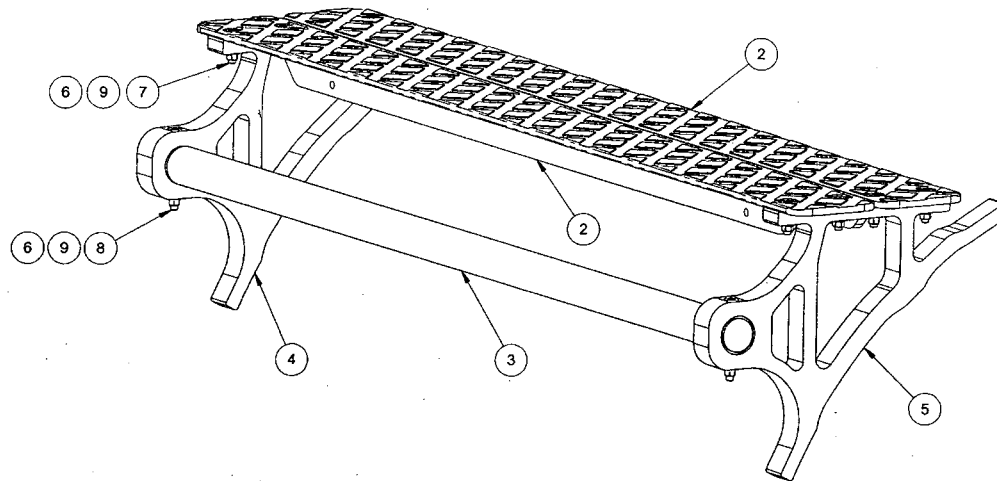
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ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D6332J	WASHER



D4526-042 MAINTENANCE STEP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84401 MJS
12/05/11

RELEASED
2011-11-28

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4526	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.11.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

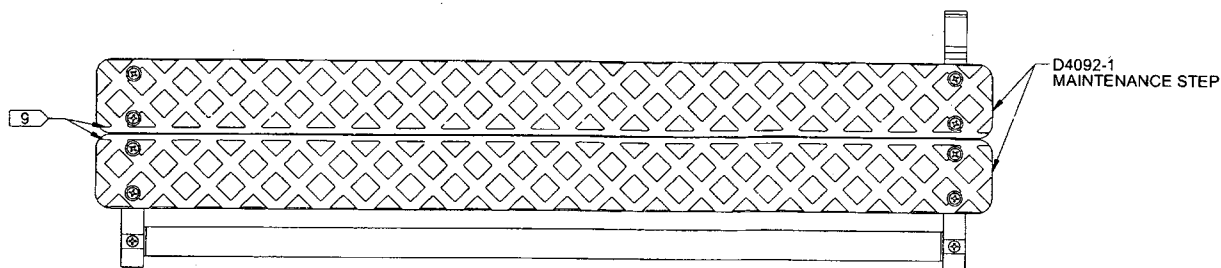
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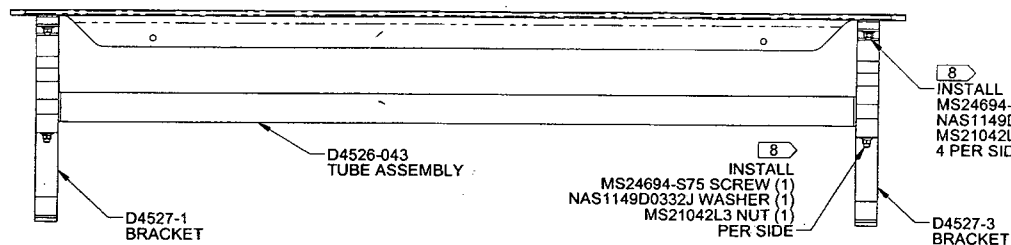
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NOTE: Date & initial all entries



D4092-1
MAINTENANCE STEP

04401



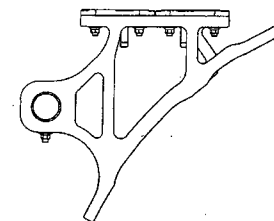
D4526-043
TUBE ASSEMBLY

D4527-1
BRACKET

INSTALL
MS24694-S75 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
PER SIDE

8
INSTALL
MS24694-S55 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
4 PER SIDE

D4527-3
BRACKET



D4526-042 MAINTENANCE STEP ASSEMBLY

RELEASED
2011-11-28
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.11.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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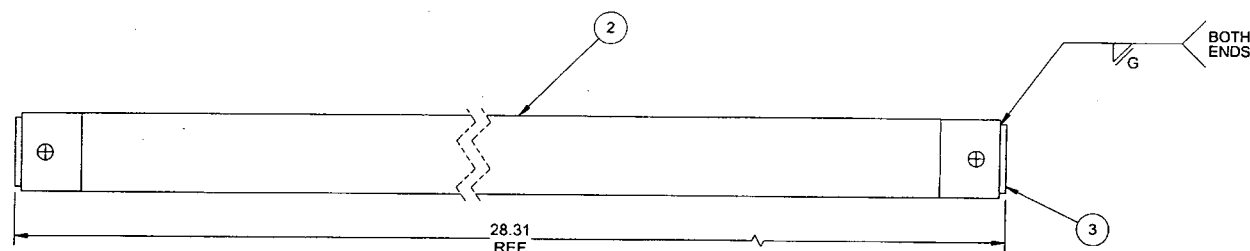
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP

84461



D4526-043 TUBE ASSEMBLY

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

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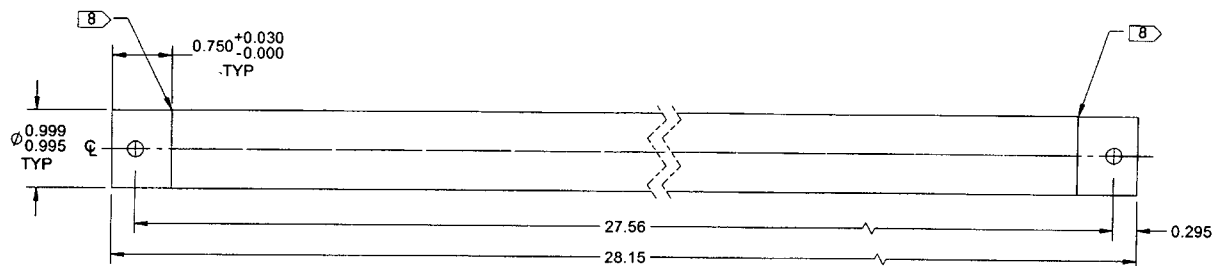
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D4526-1 TUBING

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

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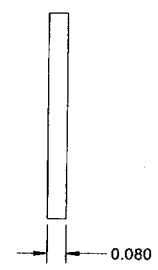
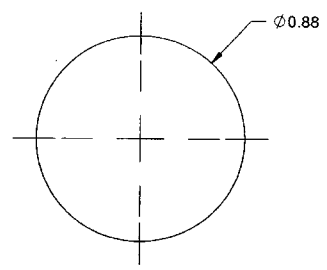
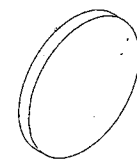
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24401



D4526-3 CAP

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

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